


Date: Monday, 12/03/2007 11:13:15 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPAD
<b>Job Number</b> : 31165	
<b>Estimate Number</b> : 12801	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D35377
<b>This Issue</b> : 12/03/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3537 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 19/03/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est Rev:A New Issue 07-03-12 ec	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 .063 Sheet
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**Comment:** Qty.: 0.1512 sf(s)/Unit Total : 0.1512 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: m101463 ml 07 03 02 ①

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: A

Prog Rev: A

ml 07 03 12 ①

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 12 ①

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

07/03/13 ①

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.

SB 07/03/14 ①

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31165

Part Number: D35377

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure toggle as per dwg D3420

*0703-14*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat  
Weld hardcoat as per Dwg D3437

*MC2755*

*FE 07/03/19 ①*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/03/19 ①*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/03/19 ①*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

*M 101601*

*m-l 07/03/19 ①*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/03/19 ①*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07/03/19 ①*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

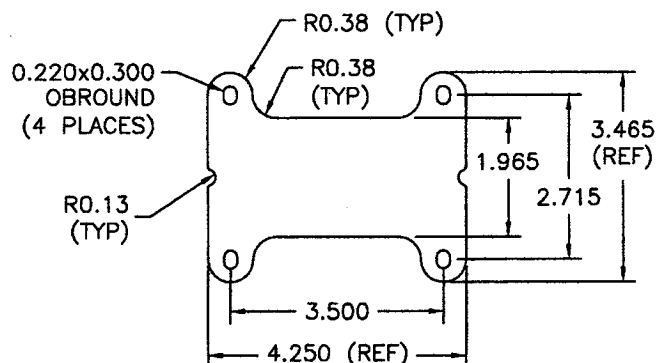
*07/03/19 ①*

Job Completion

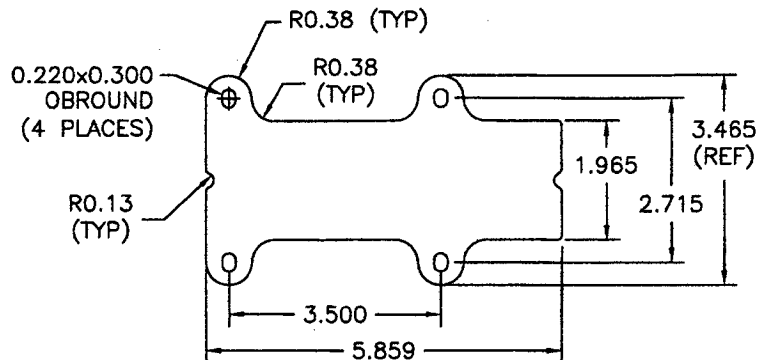


*U 07-03-19*

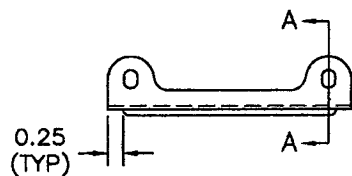
### D3537-1F FLAT PATTERN



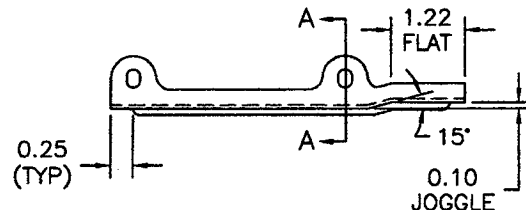
### D3537-3F FLAT PATTERN



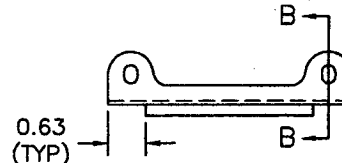
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



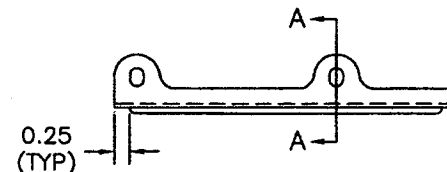
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



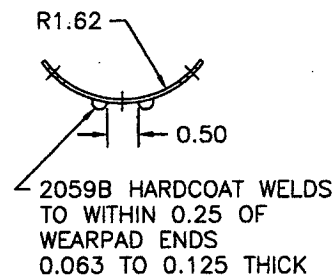
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



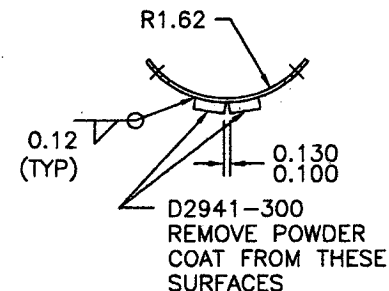
### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### SECTION A-A



### SECTION B-B



RELEASED

07.02.12

### NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE  
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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A	06.11.06	NEW ISSUE
DESIGN CB	DRAWN BY CB	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED PH	APPROVED H	DRAWING NO. D3537
DATE 06.11.06		TITLE WEARPAD
		REV. A SHEET 1 OF 1 SCALE 1:2

